



(12) **United States Patent**
Felkl

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(54) **METHOD FOR ACTUATING A TANDEM ROLL TRAIN, CONTROL AND/OR REGULATING DEVICE FOR A TANDEM ROLL TRAIN, MACHINE-READABLE PROGRAM CODE, STORAGE MEDIUM AND TANDEM ROLL TRAIN**

(58) **Field of Classification Search**
CPC G01B 11/24; B21B 37/52; B21B 1/24; B21B 1/28; B21B 38/04
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(75) Inventor: **Hans-Joachim Felkl**, Forchheim (DE)

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(73) Assignee: **PRIMETALS TECHNOLOGIES GERMANY GMBH**, Erlangen (DE)

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Primary Examiner — Kenneth M Lo

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Assistant Examiner — Olvin Lopez Alvarez

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(74) Attorney, Agent, or Firm — Slayden Grubert Beard PLLC

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(57) **ABSTRACT**

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A method is disclosed for actuating a tandem roll train, in particular a cold-strip tandem roll train, for producing a strip, e.g., a metal strip, wherein a plurality of drives are provided in a production direction of the strip, the speeds of which drives are adapted via cascade control by way of a master drive, wherein a property of the strip is determined and the direction of action of the cascade control is changed depending on said property, by a control factor (K) being provided, by way of which the direction of action of the cascade control is changed, wherein $0 \leq K \leq 1$, and wherein if

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